



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB T102137-107-103

Job Sheet 171765



Part No: RB T102137-107-103

Job Qty: 6 ea

Part Name: Strap



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/8/18

Job Tracking No:

Due Date: 2/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB T102137-107 Rev3 IPP Rev A 17.12.07 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/22/18	0.00	0.00	Start Up Waterjet		2/18/03/02
100	Waterjet	6 pcs		2/22/18	0.00	0.60	Waterjet 2 OMAX		2/18/03/02
120	Mori Seiki	6 pcs		2/23/18	0.00	6.00	45 HAAS 1 UV-5000		2/18/05/13
130	QC	6 pcs		2/23/18	0.00	0.00	9-89 QC2-2		2/18/05/13
140	QC	6 pcs		2/23/18	0.00	0.00	15-213 QC8		2/18-05-15
160	Outsource	6 pcs		2/23/18	0.00	0.00	Outsource1 ATLANTIC		2/18-5-18
180	Packaging	6 pcs		2/23/18	0.00	0.00	Packaging2		2/18/05/31
190	QC	6 pcs		2/23/18	0.00	0.00	QC6		38
200	Packaging	6 pcs		2/23/18	0.00	0.00	Packaging3-1		2/18-7-B
210	QC21-SA	6 Ea		2/23/18	0.00	0.00	QC21		2/18-7-B

Part Op 100 - 1-Cut as per Dwg Dwg Rev: 3 Prog Rev: 3 2-Deburr if necessary

Descriptions: 120 - 1-Machine as per folio FB 843 FOLIO REV: 9-89 2-Deburr 3-Using Marktronic engraver; -Engrave T/N And / or S/N number to fit. -Engrave "CAPACITY 12000 LBS." .187 font -Engrave P/N on opposite side as per DWG .16 font

ATLANTIC 160 - 1-Issue P/O to Motors P/O 039948 RC 32-38 2-Bead blast 3- Certificate of Conformity is required

190 - ***NOTE*** Cad plating to be done after load test at final assembly.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-B-1.250X6.000	AISI 4140 Round Bar Steel	6 ft (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140-B-1.250X6.000	6	0	0

Part Specifications

Specifications could not be found.

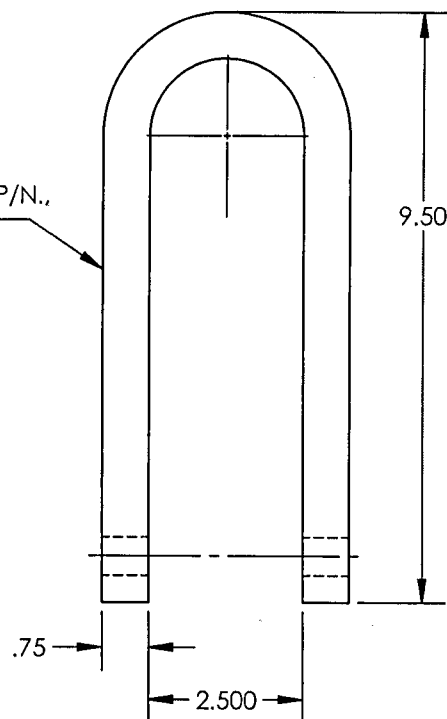
Work Order update only ☐

H:/ENBMS/Quality Assurance/Approved OA/NCBWO Bay 1

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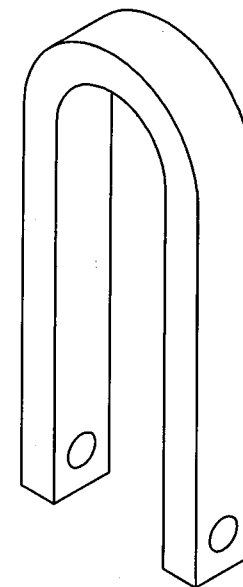
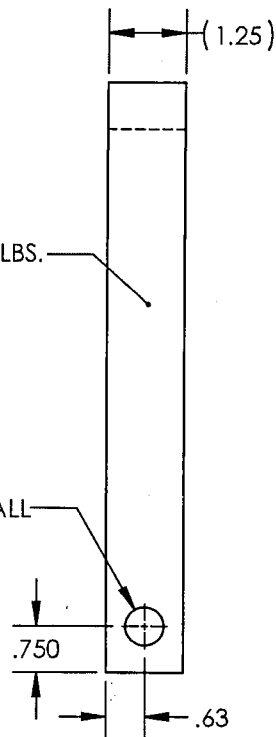
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		CHANGED PART #'S TO REFLECT THOSE OF BELL PART #'S	10/14/2010	WP	DW
1A		CORRECTED DASH # TO -103 FROM RB T102140-103.	9/13/2011	JAG	
2		CH'D DIM FROM 1.24 TO 1.25 & .620 TO .625	11/26/2013	JAG	GE
2A		-103 CH'D DIMS WAS .625 IS .63, WAS 1.25 IS (1.25).	4/9/2014	DPD	GE
3	15-0154	-103 CH'D MATERIAL CALL OUT WAS 4140 IS 4140/4142.	6/30/2015	RJC	JAG

ENGRAVE P/N.,
.16 FONT.



ENGRAVE T/N, S/N,
& "MADE IN USA" TO FIT.
ENGRAVE "CAPACITY 12000 LBS.
PROOF LOAD 24000 LBS."
3/16 FONT.

Ø .6260
.6245 THRU ALL



-103

STRAP

DART AEROSPACE	
TITLE LIFTING TOOL	
DWG NO. RB T102137-107-103	REV 3
MATL 4140/4142	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT RC 32-38
.XX ± .01 ANGLES ± 5°	FINISH CAD PLATE YELLOW
.X ± .1	SPEC QQ-P-416F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 222, 230, 407, 427, 429, 430
SCALE 1:3	DATE 7/22/2010 SHEET 2 OF 6



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039948**

Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S R14 Canada
Phone: 866 257 6395

PO No: PO039948
PO Date: 5/18/18
Due Date: 5/29/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	171765	RB T102137-107-103	Strap 1--Issue P/O to Atlantic Heat Treat; P/O _____ RC 32-38 2-Bead blast 3- Certificate of Conformity is required Material 4140	Firmed	5/29/18	6 pcs	0 pcs	6 pcs	\$13.195/pcs	\$79.17
2	173518	RBT400229-07	Top 1--Issue P/O to Atlantic Heat Treat; P/O _____ RC 32-38 2-Bead blast 3- Certificate of Conformity is required Material 4140 ***NOTE*** DROP SHIP TO FINISHER Atlantic Heat Treat to ship directly to Groupe Altech***	Firmed	5/29/18	10 pcs	0 pcs	10 pcs	\$8.513/pcs	\$85.13
3	177022	C3-12-3	Lock - C3 Hook 1--Issue P/O to Metcore ; P/O _____ RC 44-46 2-Bead blast 3- Certificate of Conformity is required Material 4140 ***NOTE*** DROP SHIP TO FINISHER Metcore to ship directly to Groupe Altech or ATG***	Firmed	5/29/18	4 pcs	0 pcs	4 pcs	\$18.75/pcs	\$75.00

Grand Total: \$239.30

Order Notes

CT

Certification

Date: 25/05/2018

Entry Date: 25/05/2018

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: po039948

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 4140

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
6	6 pcs material 4140 annealing and heat trt 32-38 rc c of c sand blast prt# rb t102137-107-103	33

Insp. Type	Scale	Minimum	Maximum	Number	Other
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Customer Requirements:

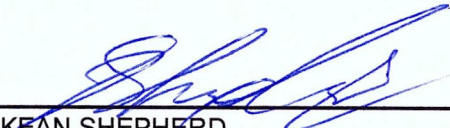
Harden rockwell

Results:

Harden ROCKWE	32.	38.	33. tested as per sampling plan
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heated 33rc with sand blast

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY). ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER. IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OF CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE FOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.


KEAN SHEPHERD
QUALITY CONTROL
ATLANTIC HEAT TREATING 2001 LTD